

# Work Order ID 56263

Wednesday, February 17, 2010 11:05:02 AM

Page 1

Item ID: D206-642-341

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Skidtube

Start Date: 2/18/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 3/4/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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100		0.00							
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DOCUMENT CONTROL									
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D206-642-341		CHG003						

110		0.00							
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Skidtubes									
Skidtubes	Memo	0.00							
Skidtubes	1-Deburr Fwd edge of tube 2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650 3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required. 4-Grind weld flush to cap on top surface only. 5-Cut af								

120		0.00							
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HandFinish									
Hand Finishing	Memo	0.00							

N/A

110.02.22

PK

1+2 DP 10-2-18

BE 10-2-18

PK

110/2/23

# Dart Aerospace Ltd

W/O: 56263		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/21/07	3	Perm. Change Fix on ADD Routing numbers	<i>ALREADY DONE See W/O 57157</i>				<i>CS</i> 10/21/07

Part No: D206-642-341 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Seq 110

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

11/2/23

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R

Aluminum Rod M112507/M113207

BE 10/2/22

4-Grind weld flush to cap on top surface only.

5-Cut aft end to length as per dwg D2650

11/2/22

6-Drill pilot holes using drill Jig DT8168A (A, & B) and DT8025. Open to  $\varnothing 0.312$ "

7-Drill holes for wearplates using DT 8028-5. Open to  $\varnothing 0.297$ ".

11/2/23

8-Open Aft Cap Hole using #6 Drill Bit

9-Open holes for Tow Ring to  $\varnothing 0.625$ " as per Dwg D2650, D2650-5 Drilling Detail

10-Remove inner indexing ridge on aft end of skid tube as per Dwg D2650

11/2/22

11-Deburr and Blow out all chips from inside the tube

11/2/23

Seq 130

1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid)

11/2/23

2-Countersink crossbolt spacer holes as per Dwg D2650 (without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-5 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs. cure time before cutting

Start Date: 10/2/23 Time: 11:00

Finish Date: 10/2/24 Time: 8:45 AM

A/R

Sikaflex-291

M112429

Sikaflex expiry date:

10/8/30

-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R

Aluminum Rod

M112507

BE 10/2/25

**Work Order ID 56263**

Wednesday, February 17, 2010 11:05:02 AM

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Item ID: D206-642-341

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Skidtube

Start Date: 2/18/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 3/4/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

0.00

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid) □ 2-Countersink crossbolt spacer holes as per Dwg D2650 (without cutting fluid) □ 3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer. □ 4-Bond D26

11/2/23

AO

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

150

0.00

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod. □ A/RAluminum Rod 11/2507 □ 2-Grind welds flush as per Dwg D2650. Masking Tape access to

BET/2/24

3.5. 69 10 11 12 19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-642-341 PAR #: N/A Fault Category: Skidhebe NCR: Yes No DQA: 1 Date: 10.04.27  
 Resolution: Re-work Disposition: Re-work QA: N/C Closed: 1 Date: 10/04/27

NCR: <u>56263</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/02/25	18	During counter boring employee broke off the pilot in the last square hole in Rnd section. After Reuben and counterboring the second time he noticed that	<i>[Signature]</i>	<del>Replace tool</del> Drill out x-bolt spaces 3, 5, 8, 9, 10, 11, 12, 15th from AFT.	<i>[Signature]</i> 10-2-25	<i>[Signature]</i> 10/04/07	<i>[Signature]</i>	<i>[Signature]</i> 10/02/25
		Holes were ovalized. QC inspector measure all holes and found qty 88 that are over 0.330" in R.C. Process.	<i>[Signature]</i>	- Replace D2649 Qty x 8 B 55000 - Re weld as per Q57004	BE 10-2-25 <i>[Signature]</i>	<i>[Signature]</i> 10/04/07	<i>[Signature]</i>	<i>[Signature]</i> 10/02/25
			<i>[Signature]</i>	- grinding <del>into</del> welds flush. - re counter bore & deburr.	BE 10-2-25 <i>[Signature]</i>	<i>[Signature]</i> 10/04/07	<i>[Signature]</i>	<i>[Signature]</i> 10/02/25

NOTE: Date &amp; initial all entries

Seq 150

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R

Aluminum Rod M112507 BE 10/02/24

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube BE 12/02/25

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Debur

BE 12/02/25

Seq 190

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

Seq 220

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R

Sikaflex-291

Sikaflex expiry date: \_\_\_\_\_

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R

Sikaflex-291

Sikaflex expiry date: \_\_\_\_\_

6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4

Batch: \_\_\_\_\_

**Work Order ID 56263**

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Item ID: D206-642-341

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Setup Start

Revision ID:

Stop

Item Name: Replacement Skidtube

Start Date: 2/18/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 3/4/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

Install D2680-041 Nut Plate as per Dwg D2650

BE 10/02/25

170

0.00



QC10- Inspect visual per QSI004- ground welds

QC

Memo

0.00

Quality Control

8 10/02/26

180

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8 10/02/26

(X)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Item ID: D206-642-341

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Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 2/18/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 3/4/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

Pressure Wash per QSI005 4.3

0.00



HandFinish *HandFinish* *Pressure Wash per QSI005 4.3* *11/13/70* *10/03/09*

HandFinish

Memo

0.00

Hand Finishing

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



*11/13/70*

Powdercoat

Memo

0.00

Powder Coating

START TIME:

*1:15pm*

OVEN TEMPERATURE:

*1:45pm* FINISH TIME:

*320°F*

210

QC3- Inspect Part Finish

0.00



*BR 10-3-31*

QC

Memo

0.00

Quality Control

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 56263

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Item ID: D206-642-341

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Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 2/18/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 3/4/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

220



HandFinish

Hand Finishing

HandFinishing

Memo

0.00

0.00

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. ☐ A/R Sikaflex-29 113402 ☐ Sikaflex expiry date: 10/08 ☐ 2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly

Dec. 02.22

Wing Walk Batch 113402

BR 10-4-6

①

230



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

Sio/04/07

240



QC

Quality Control

QC5- Inspect part completeness to step on W/C

Memo

0.00

0.00

Sio/04/07

(FK)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 56263**

Wednesday, February 17, 2010 11:05:02 AM

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Item ID: D206-642-341

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Skidtube

Start Date: 2/18/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 3/4/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-341 <input type="checkbox"/> Location: _____ <input type="checkbox"/> PPP Rev: _____								
		P/P							
260	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

56261

10/04/26

10/04/27

MF  
10-4-27

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, February 17, 2010 11:05:01 AM

Page 1

Work Order ID: 56263

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Comments: IPP Rev: H05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM  
IPP Rev: I 08-09-29 revF as per dwg DD verified by:

Start Date: 2/18/2010

Required Date: 3/4/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS4-1032-130		Purchased	No				Each	1,908.000	54.0000			



Insert

Warehouse Loc Qty Loc Code

Location

ALS7-1032-130.

Main Warehouse 113288.

ST 1908

110511 1908

AN960C10L Purchased No

Each 388.0000 54.0000



washer

Warehouse Loc Qty Loc Code

Location

\* NAS 1149-C0832R

OFFSHORE 113691.

FG 100

103585 100

Main Warehouse

ST 288

112116 128

112612 160

54. BR 10-4-6.

54. BR 10-4-6.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist, Print

Page 2

Wednesday, February 17, 2010 11:05:01 AM

Work Order ID: 56263



Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 2/18/2010

Required Date: 3/4/2010

Comments: IPP Rev: H05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM  
IPP Rev: I 08-09-29 revF as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10L		Purchased	No				Each	3,457.000	2.0000			
Washer												

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

3457

101291

16

105793

49

110985

3392

Each

0.0000

1.0000

\* AN960JD416

Purchased

No



Washer

CCR264SS3-3

Purchased

No



Cherry Rivet

Each

521.0000

2.0000

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

ST

29

111548

20

111827

1

112314

2

113539

6

Main Warehouse

ST311

492

113973

492

2. 02/10-4-6

1 02/10-4-6

2 BE 10/02/25

Wednesday, February 17, 2010 11:05:01 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 56263



Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 2/18/2010

Required Date: 3/4/2010

Comments: IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM  
IPP Rev: I 08-09-29 revF as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
CR3212-4-03		Purchased	No				Each	242.0000	2.0000			
Cherry Rivet												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	242	
111359	84	
112314	158	

D2620

Manufactured No



Skidtube, 206 Skidtube

Each 10.0000 1.0000



2 BE 10-2-25

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	10	
55559	10	

1

DP 10-2-18

Wednesday, February 17, 2010 11:05:01 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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IPP Rev: I 08-09-29 revF as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2646		Manufactured	No				Each	55.0000	1.0000			
Aft Cap												

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
FP6	29	
52663	29	
Main Warehouse		
fp7	13	
52663 ✓	13	
Main Warehouse		
ST	13	
46327	4	
48109	9	

D2647		Manufactured	No				Each	90.0000	1.0000			
Cap												

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	90	
55352	90	

1 BR 10-4-6

1 BG 10/2/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 5

Wednesday, February 17, 2010 11:05:01 AM

Work Order ID: 56263



Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 2/18/2010

Required Date: 3/4/2010

Comments: IPP Rev: H05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM  
IPP Rev: I 08-09-29 revF as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2649		Manufactured	No				Each	245.0000	19.0000			
Cross Bolt Spacer												

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
LG	218	
51529	3	
55000	215	
Main Warehouse		
ST	27	
36013	5	
47112	18	
48271	4	

D2651-1	Manufactured	No	Each	450.0000	14.0000
Plug					

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
fpa	295	
53349	295	
Main Warehouse		
ST	155	
51530	155	

19 BB 10/02/24

14 PR 10-4-6

Wednesday, February 17, 2010 11:05:01 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, February 17, 2010 11:05:01 AM

Work Order ID: 56263



Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 2/18/2010

Required Date: 3/4/2010

Comments: IPP Rev: H05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM  
IPP Rev: I 08-09-29 revF as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2651-3		Manufactured	No				Each	639.0000	14.0000			
O-Ring												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

639

43849

3

46114

636

Manufactured No

Each

4.0000

1.0000

14. *BE 10-4-6*

D2654-5



Web

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

4

46638

4

Manufactured No

Each

54.0000

1.0000

1 *11/2/23*

D2680-041



Nut Plate

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST021

54

33061

1

55366

53

1 *BE 10/02/25*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, February 17, 2010 11:05:01 AM

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Work Order ID: 56263



Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 2/18/2010

Required Date: 3/4/2010

Comments: IPP Rev: H05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM  
IPP Rev: I 08-09-29 revF as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3535-11		Manufactured	No				Each	8.0000	1.0000			
Wearshoe												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

46647 ✓

8

8

Each

10.0000

1.0000



1 BL 10-4-6.

D3535-23



Wearshoe

Manufactured No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

53467 ✓

10

10

Each

17.0000

1.0000



1 BL 10-4-6.

D3535-35



Wearshoe

Manufactured No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

51608 ✓

17

17

1 BL 10-4-6.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, February 17, 2010 11:05:01 AM

Page 8

Work Order ID: 56263



Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 2/18/2010

Required Date: 3/4/2010

Comments: IPP Rev: H05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM  
IPP Rev: I 08-09-29 revF as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3536-11		Manufactured	No				Each	16.0000	1.0000			
Gasket												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	16	
46649 ✓	12	
46715	4	

D3536-23  
  
Gasket

Manufactured No

Each 16.0000 1.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	3	
51609	3	
Main Warehouse		
ST	13	
30754 ✓	1	
53468 ✓	12	

*BR 10-4-6.*

*BR 10-4-6.*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Wednesday, February 17, 2010 11:05:01 AM

Work Order ID: 56263



Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 2/18/2010

Required Date: 3/4/2010

Comments: IPP Rev: H05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM  
IPP Rev: I 08-09-29 revF as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3536-35		Manufactured	No				Each	19.0000	1.0000			
Gasket												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

19

51628 ✓

19

Each

153.0000

6.0000

*1 PR 10-4-6.*

D3537-1



Wearpad

Manufactured No

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

74

48288

2

55465 ✓

72

Main Warehouse

FP17

79

51678

1

51679

78

*6 PR 10-11-6.*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, February 17, 2010 11:05:01 AM

Work Order ID: 56263



Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 2/18/2010

Required Date: 3/4/2010

Comments: IPP Rev: H05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM  
IPP Rev: I 08-09-29 revF as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3537-3		Manufactured	No				Each	32.0000	1.0000			

Wearpad

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	32	
33881	4	
35697 ✓	28	

MS27039-1-08

Purchased

No

Each 2,169.000 2.0000



Screw

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	2169	
110467	3	
110552	166	
110835 ✓	2000	

1 BL 10-4-6.

2 BL 10-4-6.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Wednesday, February 17, 2010 11:05:01 AM

Work Order ID: 56263



Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 2/18/2010

Required Date: 3/4/2010

Comments: IPP Rev: H05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM  
IPP Rev: I 08-09-29 revF as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-08		Purchased	No				Each	2,169.000	54.0000			
Screw												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2169	
110467	3	
110552	166	
110835 ✓	2000	

MS27039-4-06 Purchased No

Screw

Each 49.0000 1.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	49	
109061 ✓	49	

54.6R 10-4-6

1 10-4-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

# 56263

RELEASED  
08.07.23/17

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW: INCORP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

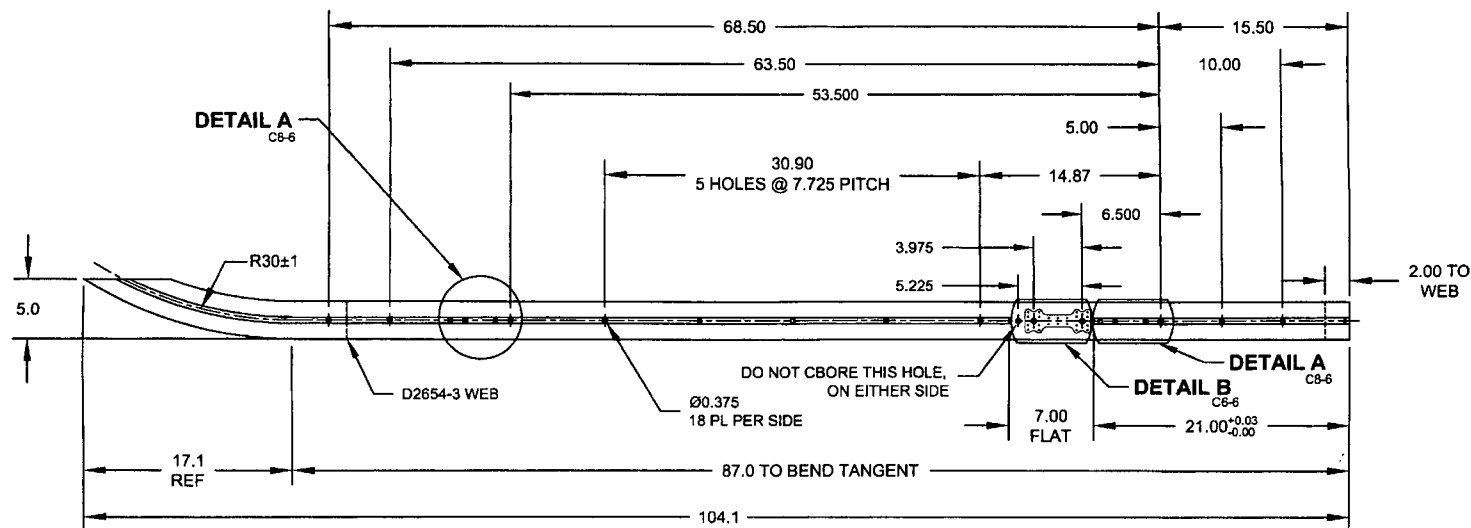
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

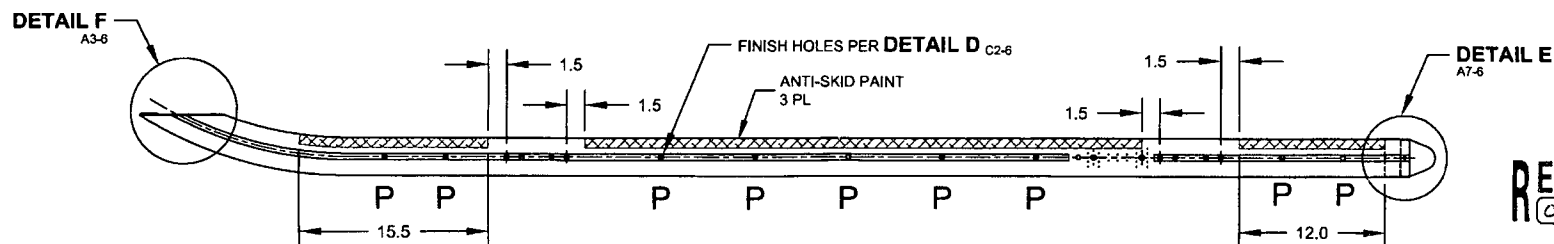
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries









**D2650-3 BENDING/DRILLING DETAIL**



**D2650-3 ASSEMBLY/FINISHING DETAIL**

**RELEASED**  
05 07 22 118

DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1987 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

# Dart Aerospace Ltd

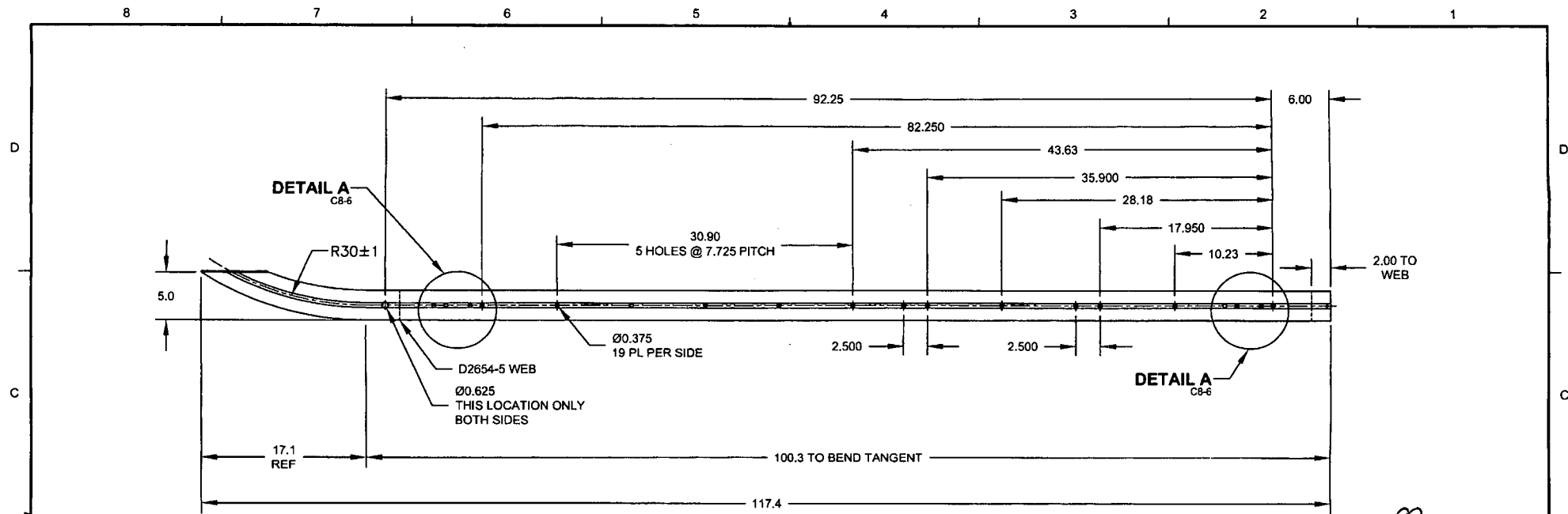
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

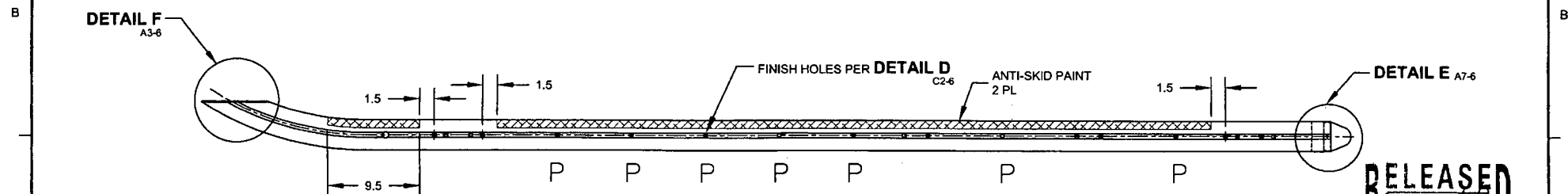
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D2650-5 BENDING/DRILLING DETAIL**



**D2650-5 ASSEMBLY/FINISHING DETAIL**

DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D2650	SHEET 4 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

**RELEASED**  
08.09.22.117

#56263

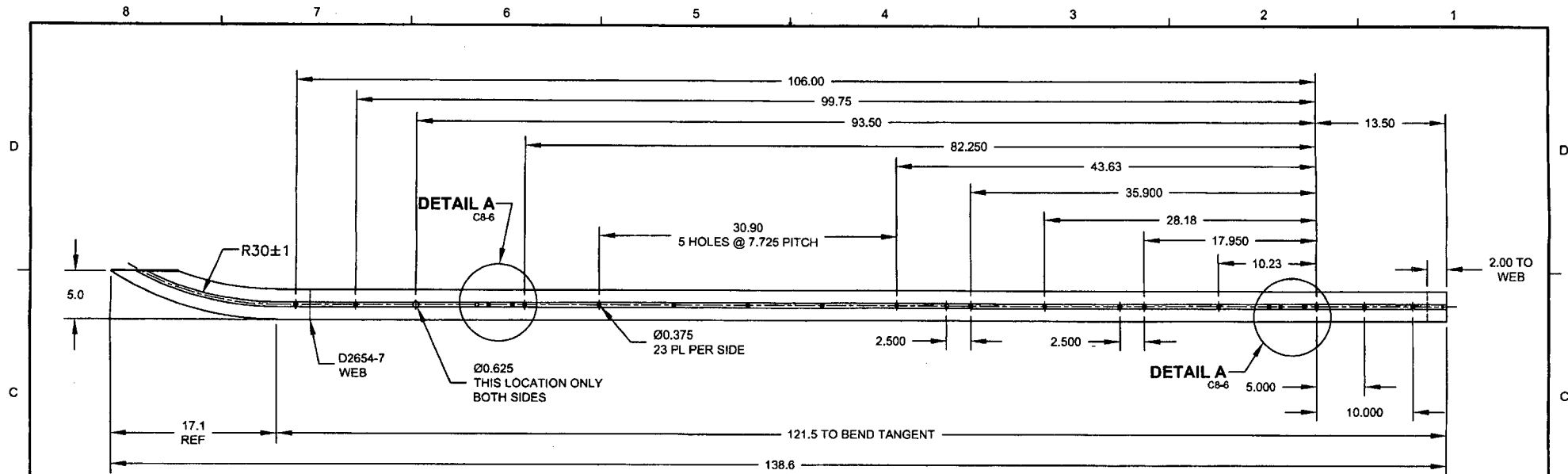
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

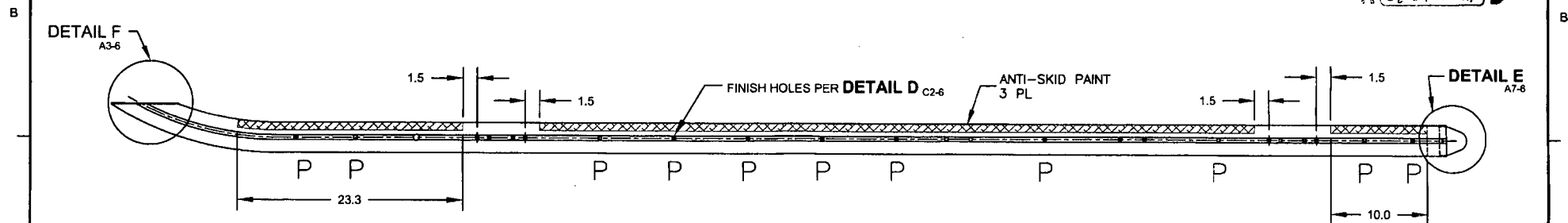
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D2650-7 BENDING/DRILL DETAIL**



**D2650-7 ASSEMBLY/FINISHING DETAIL**

DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COME OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

**RELEASED**  
08 07 22

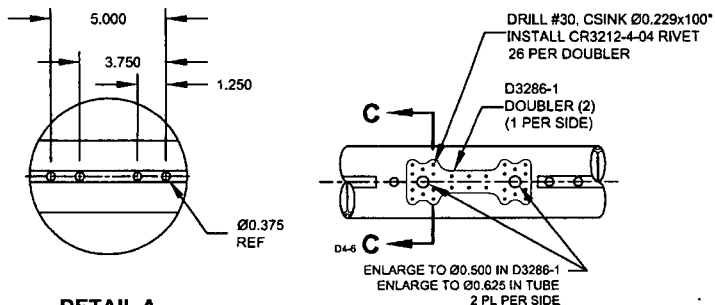
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

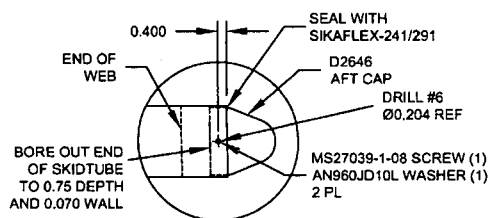
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

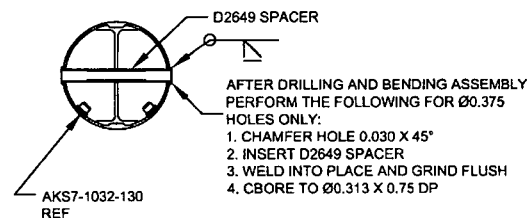
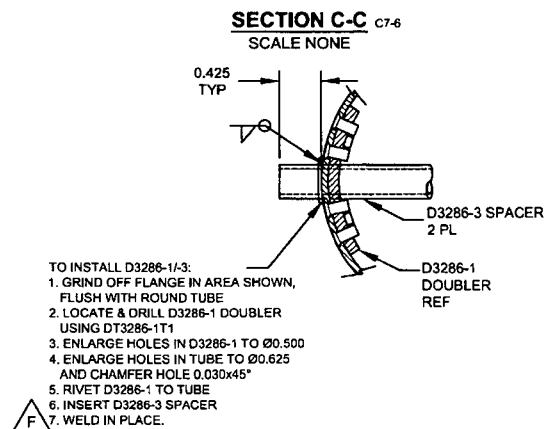


**DETAIL A**  
SCALE 2X  
C2-2  
D7-2  
D7-3  
C2-4  
D7-4  
C2-5  
D6-5

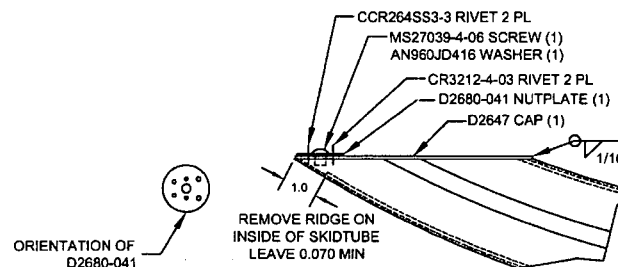
**DETAIL B**  
SCALE 2X  
C3-2  
C3-3



**DETAIL E**  
SCALE 2X  
B2-2  
B2-3  
B1-4  
B1-5



**DETAIL D**  
FOR Ø0.375 HOLES ONLY  
SCALE 3X  
B4-2  
B4-3  
B4-4  
B4-5



**DETAIL F**  
SCALE NONE  
B8-2  
B8-3  
B8-4  
B8-5

- DETAIL F NOTES:**
1. CUT TUBE LEVEL
  2. REMOVE RIDGE ON FWD SIDE
  3. LOCATE D2647 (TRIM AS NECESSARY)
  4. WELD D2647 IN PLACE PER DART QSI 004
  5. GRIND FLUSH
  6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

**RELEASED**  
05-09-22-18

DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



NO. 323

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Berclay Elliott  
Job number: 55777  
Part number: 0206-642-441  
Description: 206 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Rat. Int. Date of Test Coupon 10.02.16

Welder Berclay Elliott Date of Test Coupon 10-02-16

The above named individual is qualified in accordance with AWS D17.1.2001 to weld